

ABSTRAK

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Program Studi : Teknik Industri
Judul Skripsi : Implementasi Metode QCC untuk Pengukuran
Reject Size Partial Squegee Mesin KTL-1 pada
Proses Produksi Ban
Pembimbing : Dr. Agus Ismail, S.Si., M.Eng.

Penelitian ini dilakukan di industri manufaktur produsen ban, penelitian ini membahas studi kasus perbaikan kualitas *Tubeless Squegee Partial*, dengan mengidentifikasi *defect Tubeless Squegee Partial* pada proses pembuatan *Tubeless Size Partial Squegee*. Total *defect* di Mesin KTL-1 pada periode Januari 2023-April 2023 sebesar 7.174.881 m dari total jumlah produksi yaitu sebesar 7.712.621 m. Dari jumlah tersebut didapatkan persentase *defect* sebesar 93% yang melewati batas toleransi *defect* perusahaan yaitu sebesar 5%. Observasi lapangan dan pengumpulan data hasil produksi serta data *defect* produk sebagai metode pengumpulan data. Berdasarkan hasil penelitian, dengan implementasi Metode QCC (*Quality Control Circle*) jenis *defect* pada *Tubless Squegee Partial* dapat teridentifikasi. Kemudian faktor-faktor penyebab masalah *Tubeless Squegee Partial* dapat teridentifikasi, yaitu permukaan *roll press* tidak rata karena terkikis gesekan, bearing tidak terlumasi dengan baik, serta dudukan silinder tidak rata. Sehingga dari hasil analisis tersebut dapat memberikan usulan perbaikan dari masalah *defect Tubeless Squegee Partial*. Dari hasil perbaikan yang sudah dijalankan menggunakan Metode QCC (*Quality Control Circle*), yaitu memperbaiki dudukan silinder yang tidak rata dan memperbaiki permukaan *roll press* yang terkikis akibat gesekan. Implementasi tindakan perbaikan berhasil menurunkan *Reject Rate Tubeless Partial Squegee* dari 92% menjadi 7%.

Kata Kunci: *Defect*, Kualitas, QCC

ABSTRACT

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Title of Thesis Report : *Implementation of the QCC Method for Measuring the Reject Size of Partial Squeegee on the KTL-1 Machine in the Tire Production Process*
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This research was conducted in the tire manufacturing industry, this research discusses a case study of improving the quality of Partial Tubeless Squeegee, by identifying Partial Tubeless Squeegee defects in the process of making Tubeless Size Partial Squeegee. The total defects in the KTL-1 Machine in the period January 2023-April 2023 amounted to 7,174,881 m from the total production amount of 7,712,621 m. From this amount, the defect percentage was obtained at 93%, which exceeded the company's defect tolerance limit, namely 5%. Field observations and collection of production data and product defect data as data collection methods. Based on the research results, by implementing the QCC (Quality Control Circle) method, the types of defects in Tubless Squeegee Partial can be identified. Then the factors causing the Tubeless Squeegee Partial problem can be identified, namely the roll press surface is uneven due to wear out by friction, the bearing is not lubricated properly, and the cylinder seat is not flat. So that the results of this analysis can provide suggestions for improvements to the Tubeless Squeegee Partial defect problem. From the results of improvements that have been carried out using the QCC (Quality Control Circle) method, namely repairing uneven cylinder seats and repairing the surface of the roll press which has been wore out due to friction. Implementation of corrective actions succeeded in reducing the Tubeless Partial Squeegee Reject Rate from 92% to 7%.

Keywords: *Defect, Quality, QCC*